

Work Order ID **77036** - *f***\*77036\*****U/R**

Page 1

Item ID: D3537-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearpad

Start Date: 24/11/2011 Start Qty: 50.00

**\*50\***

Cust Item ID:

Required Date: 08/12/2011 Req'd Qty: 50.00

**\*50\***

Customer:

Reference:

Approvals: Process Plan: *M.C.J*Date: *11/11/25*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3537

Rev C U/R

*OK 11.11.28*

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537Dwg Rev *CUR* Prog Rev *CUR* 2-Deburr  
if necessary*11-12-3**(60)*

110

0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*11-12-3*

120

0.00

**\*120\***

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*8/11/2015**Went to  
(160)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 77036

**\*77036\***

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November-24-11 3:40:26 PM

Item ID: D3537-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearpad  
 Start Date: 24/11/2011 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 08/12/2011 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
<b>*130*</b>									
Brake NC	Memo	0.00							
Brake NC	1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2- Identify as D3537-1								
140	Large Fab	0.00							
<b>*140*</b>									
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch/A/R 2059B Hardcoat 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any weld that penetrated through Wearpad if necessary								
150	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

60

SB 11/12/11

28 12-01-04 1056

counts  
+28

8 12/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Work Order ID 77036

\*77036\*

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November-24-11 3:40:26 PM

Item ID: D3537-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Wearpad  
 Start Date: 24/11/2011 Start Qty: 50.00 \*50\* Cust Item ID:  
 Required Date: 08/12/2011 Req'd Qty: 50.00 \*50\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC5- Inspect part completeness to step on W/O 0.00

\*160\*

QC

Quality Control

Memo

0.00

170 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

\*170\*

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

180 QC3- Inspect Part Finish 0.00

\*180\*

QC

Quality Control

Memo

0.00

W 118489

11:50  
 3200F  
 12:20

28x7 m-f 12/01/04

28 BX 12-1-4

counts  
 48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**\*77036\***

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November-24-11 3:40:26 PM

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 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <i>FR2</i>	0.00							
<b>*190*</b>									
Packaging	Memo	0.00				<i>28</i>	<i>BL</i>	<i>12-1-4</i>	
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

*OK 12/01/04*  
*MR 12-1-4*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

November-24-11 3:40:30 PM

Page 1

Work Order ID: 77036

\*77036\*

Parent Item: D3537-1

\*D3537-1\*

Parent Item Name: Wearpad

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	303.6000	0.106	5.578947			

\*M304S16GA\*

304/316 Sheet .063

\*\*

BIT-12-3

Location

Loc Qty

Loc Code

MAT020

303.6

119346

26.6

119653

277

119653

W/O:		WORK ORDER CHANGES					
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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SHOP COPY  
RETURN TO  
ENGINEER  
UNCONTROLLED COPY

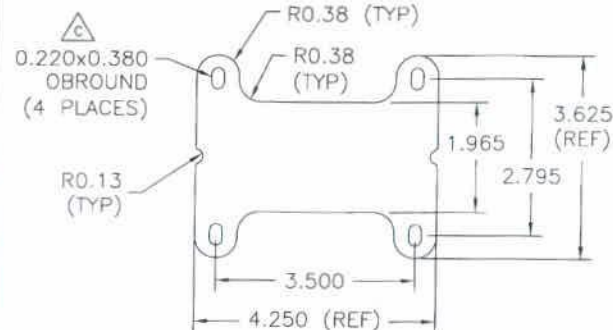
SUBJECT TO AMENDMENT

WITHOUT NOTICE

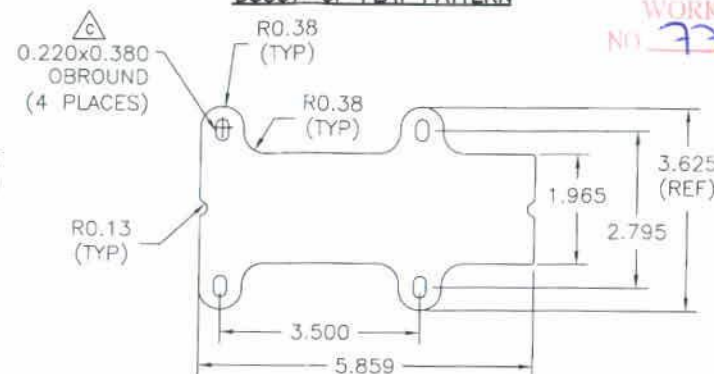
WORK ORDER

NO 77036 M.C.J  
11/11/25

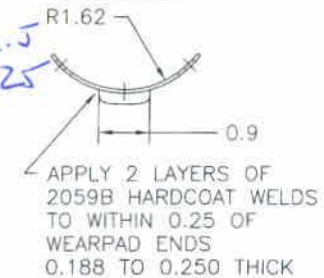
### D3537-1F FLAT PATTERN



### D3537-3F FLAT PATTERN

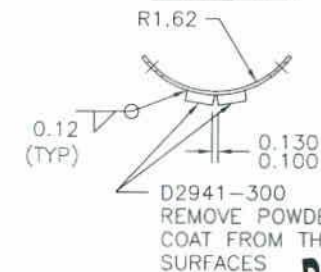


### SECTION A-A



OK 11/11/25

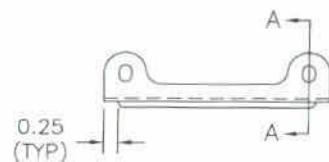
### SECTION B-B



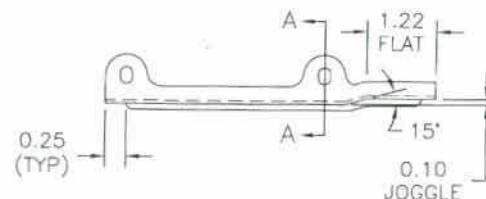
UNDER REVIEW  
11/11/25  
Change

RELEASED  
07.05.08 PM  
per ECAJ  
962

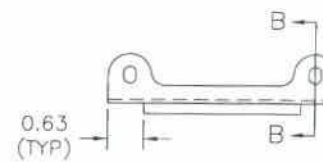
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



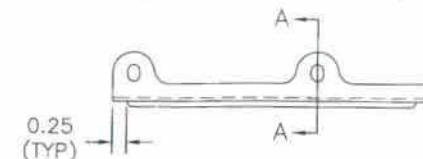
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1/2

**DART** DART AEROSPACE USA, INC.  
PORT HAZARD, MA



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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